

Work Order ID 56302

February 17, 2010 2:28:37 PM

Page 1

Item ID: D2056

Accept

Setup Start

Revision ID:

Stop

Item Name: Bell Crank

Start Date: 2/17/10 Start Qty: 6.00

Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *RF*

Date: *10-2-17* Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2056

Rev B2

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 2.80" long

MNF
10/02/18

6 *0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2056
Tumble
Deburr

MNF
10/02/18

6 *0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MNF
10/02/18

6 *0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

ant 10/02/18

6 2

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

BK 10-02-22

6 2

HandFinish

Memo

0.00

Hand Finishing

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

11 105662

0.00

BK 10-02-22

6 2

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*1:30
325°
2:00*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ m. l 10/02/22

(6x)

170

Identify as per dwg & Stock Location: 6

0.00



Packaging

Memo

0.00

Packaging

P10/4/26 (6)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 HJ

C2 03/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 56302



Parent Item: D2056

Parent Item Name: Bell Crank

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP E02.04.04 Added Rev.B2 [ENGL]

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	52.3800	1.5000			



6061-T6 Bar 1.25 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

52.38

106259

14

109058

21.43

110001

16.95

1.500

mmf 10/08/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56302
Description: Bell Crank		Part Number:	D2056
Inspection Dwg: D2056 Rev: B2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	.752	✓			
0.900	+/-0.010	.901	✓			
1.000	+/-0.010	1.002	✓			
0.125	+/-0.010	.121	✓			
0.060	+/-0.010	.062	✓			
Ø0.191	+0.005/-0.001	.195	✓			
0.362	+/-0.010	.360	✓			
0.750	+/-0.010	.752	✓			
0.385	+/-0.010	.385	✓			
Ø0.257	+0.006/-0.001	.260	✓			
0.100	+/-0.010	.101	✓			
0.300	+/-0.010	.299	✓			
0.946	+/-0.010	.946	✓			
0.075	+/-0.010	.075	✓			
2.637	+/-0.010	2.638	✓			
0.375	+/-0.010	.376	✓			
Ø0.513-0.518	0.513 - 0.518	Ø.516	✓			
R0.450	+/-0.010	R.450	✓			
R0.125	+/-0.010	R.125	✓			
R0.200	+/-0.010	R.200	✓			
R0.550	+/-0.010	R.550	✓			
R0.263	+/-0.010	R.263	✓			

Measured by:	MJE
Date:	10/02/18

Audited by:	mf
Date:	10/02/18

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	
B	10.02.02	Dimensions revised	KJ	

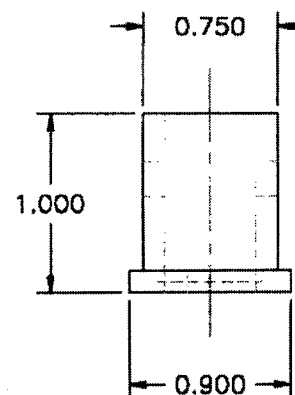
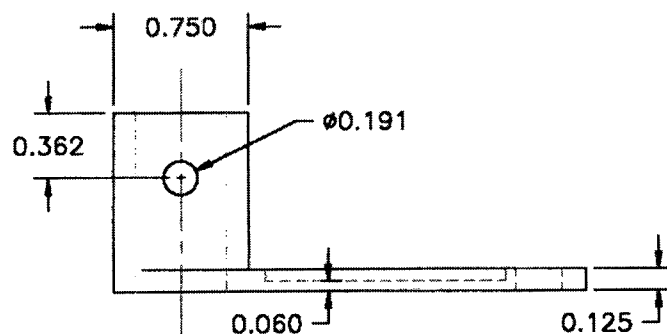
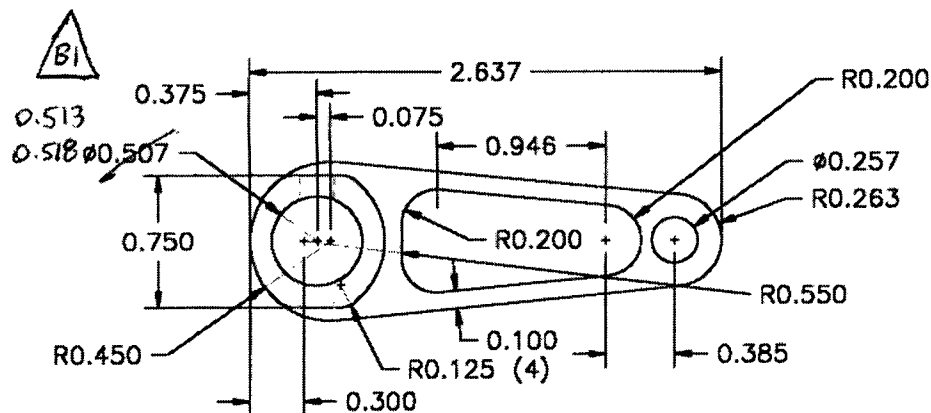
DART



RELEASED
99.04.26 JCE

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
B WILLIAMS	K HAND		
CHECKED	APPROVED	DRAWING NO. D2056	SHEET 1 OF 1
DATE 92.03.13	DATE 95.11.02	TITLE BELL CRANK	SCALE 1:1
B	RE-DESIGN		
B1	01.06.04	MODIFY HOLE SIZE, ADD PIC OPTION	
B2	01.12.20	ADD NOTE ON TOLERANCES	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56302
Ref 10-2-1-



B1 ACID ETCH & ALODINE PER
DART QSE COS 4.1
POWDER COAT BLACK SHIMMER
(4.3.5.7) PER DART
QSE COS 4.3

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR
TOLERANCES ARE PER DART QSE 01B UNLESS OTHERWISE NOTED.

B2